

Work Order ID 87756

July-11-12 11:38:08 AM

ASD
87756

Page 1

Item ID: D3695-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Slider Assembly
 Start Date: 7/11/12 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 7/13/12 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *W* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3695	Rev D								
100		0.00							
100	Small Fab								
Small Fab	Memo	0.00							
Small Fab	1- install heli-coil as per dwg D3695 2- install D3695-3 and spring plug as per dwg D3695								
110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									
120	Identify as per dwg & Stock Location: <i>51255</i>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

8/26/13 DAS 16 8-89

12-7-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87756***87756***

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Item ID: D3695-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Slider Assembly
Start Date: 7/11/12 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 7/13/12 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

OK 12/7/13

MF
12-07-23

Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

July-11-12 11:38:08 AM

Page 1

Work Order ID: 87756
Parent Item: D3695-041
Parent Item Name: Slider Assembly

Start Date: 7/11/12
Start Qty: 1.00

Required Date: 7/13/12
Required Qty: 1.00

Comments: IPP Rev:A new issue 08-03-27 DD verified by:ec
IPP Rev:B 09-01-13 revC as per dwg DD verified by:ec
revD DD verf:JLM
IPP rev:C 10.11.29 as per dwg

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3695-1 Slider		Manufactured	No			100	Each	5.0000	1	1		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST259		5							
				86223		5							
D3695-3 Stopper		Manufactured	No			100	Each	3.0000	1	1		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST255		3							
				56853		3							
D3801-1 Hand Retractable Spring Plunger		Manufactured	No			100	Each	69.0000	1	1		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST064		69							
				75178		10							
				81860		19							
				82615		40							
MS21209-F120 HELI COIL		Purchased	No			100	Each	125.0000	4	4		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		125							
				114037		29							
				121709		96							
MS21209-F625 Heli-Coil		Purchased	No			100	Each	66.0000	1	1		7/12/07/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST304		66							
				108138		66							

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Picklist Print

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Work Order ID: 87756

Parent Item: D3695-041

Parent Item Name: Slider Assembly

Start Date: 7/11/12

Required Date: 7/13/12

Start Qty: 1.00

Required Qty: 1.00

MS24693-C276

Purchased

No

100

Each

126.0000

4

4

Screw

Location

Loc Qty

Loc Code

ST310

126

113845

100

9599

26

4

EB 07/12

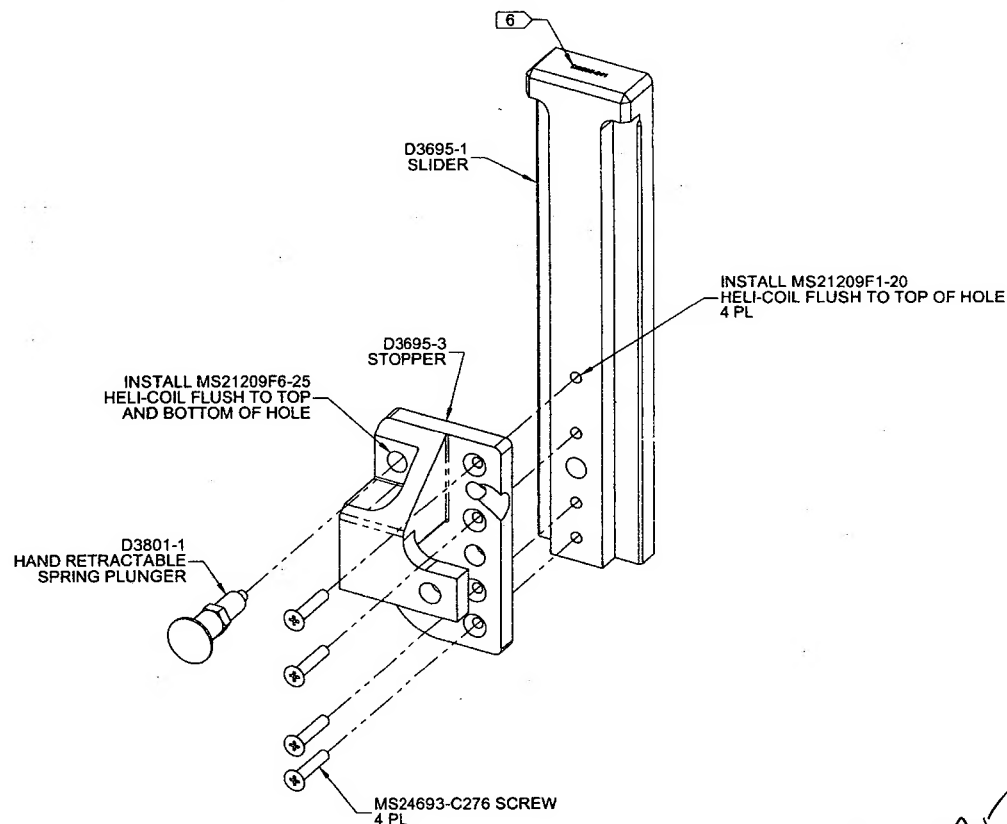
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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D3695-041 SLIDER ASSEMBLY

D3695-041 NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENT P/N "D3695-041" PER QSI 044 6.1
- 7) WEIGHT: D3695-041 = 0.63 lbs

ITEM	QTY	P/N	DESCRIPTION
1	X	D3695-041	SLIDER ASSEMBLY
11	1	D3695-1	SLIDER
12	1	D3695-3	STOPPER
15	1	D3801-1	HAND RETRACTABLE SPRING PLUNGER
21	4	MS21209F1-20	HELI-COIL, SCREW LOCKING (RED)
22	1	MS21209F6-25	HELI-COIL, SCREW LOCKING (RED)
23	4	MS24693-C276	SCREW

RELEASE
2010-11-25

D	NOTE 6 UPDATED PER QSI. DIM 0.994 ^{+0.000} / _{-0.010} WAS 1.000 ^{+0.000} / _{-0.010} & 0.503 WAS 0.500 (ZN C8-2). REF NCR 10-324. CHAMFER ADDED TO D3695-1 (ZN C5-2)	JPH	10.09.24
C	UPDATED BOM TO CURRENT STANDARDS, REVISED ITEM 12 (ZN D3-1); DIMS 1.83 AND 1.075 ^{+0.010} / _{-0.005} WERE 1.81 AND 1.063 ^{+0.010} / _{-0.005} (ZN 88-3 AND C4-3). REASON: COMPENSATE FOR PAINT THICKNESS AND ELIMINATE RATTLE UPON ASSEMBLY.	MB	08.11.04
B	P/N D3808-1 WAS WIP-510 (ZN C7-1 AND D3-1) - REASON: PURCHASED PARTS NOW PROCURED THROUGH D3801 SPEC CONTROL DRAWING	MB	08.06.28
A	NEW ISSUE	MB	08.03.14
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. D
MFG. APPR.	JPH	D3695	SHEET 1 OF 3
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	SLIDER ASSEMBLY	NTS
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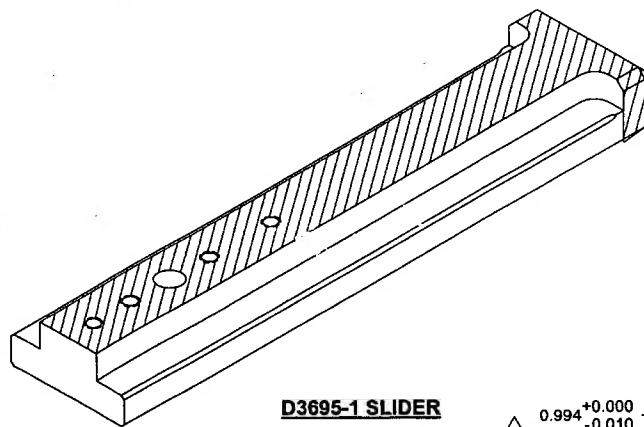
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

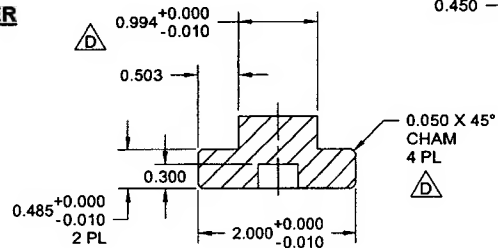
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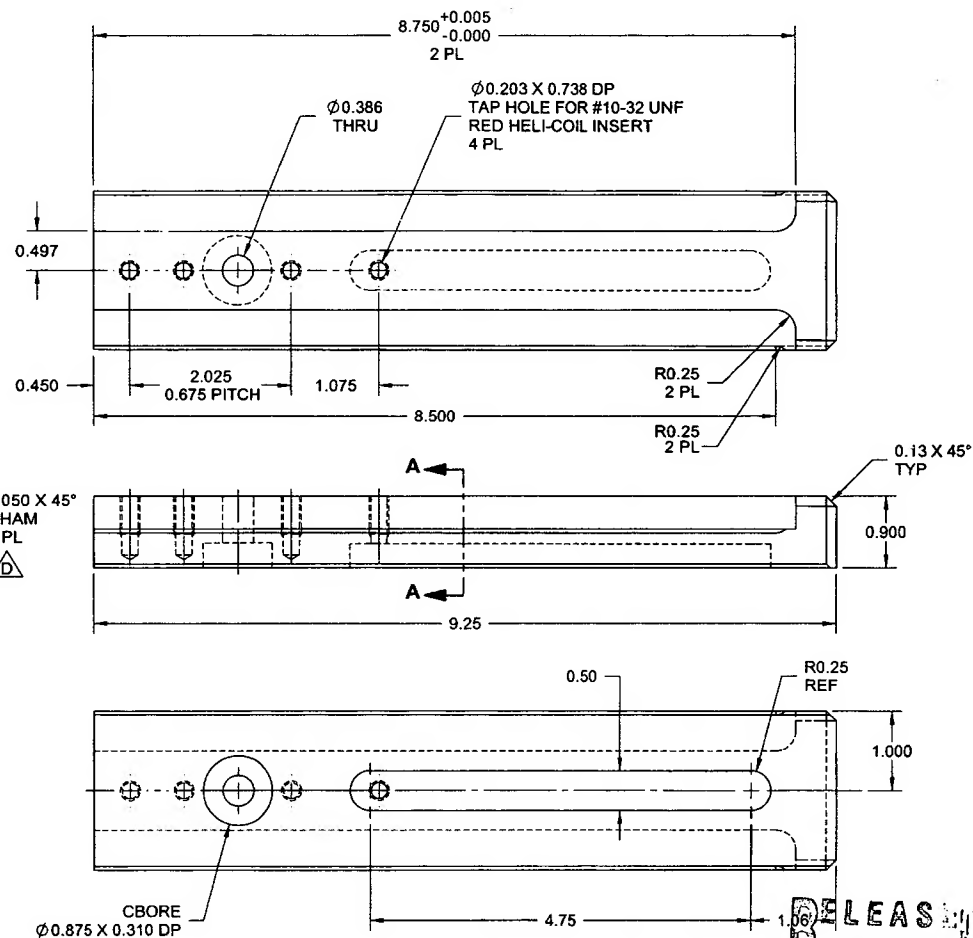
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D3695-1 SLIDER



SECTION A-A



D3695-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T6511/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3 - MASK ALL HOLES AND UNHATCHED AREAS
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.43lbs

DESIGN	JPH	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3695	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		SLIDER ASSEMBLY	NTS
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RELEASED
2010-11-25

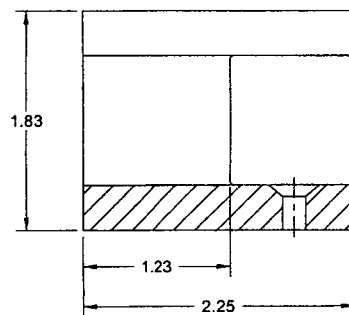
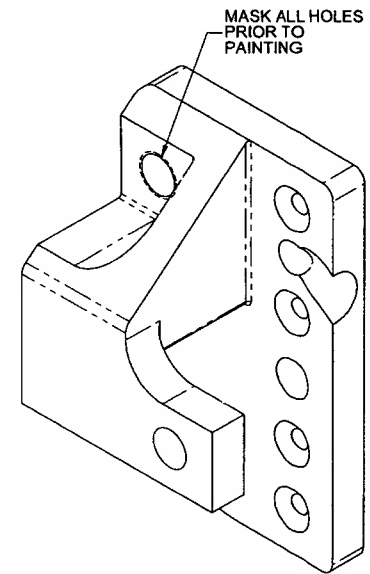
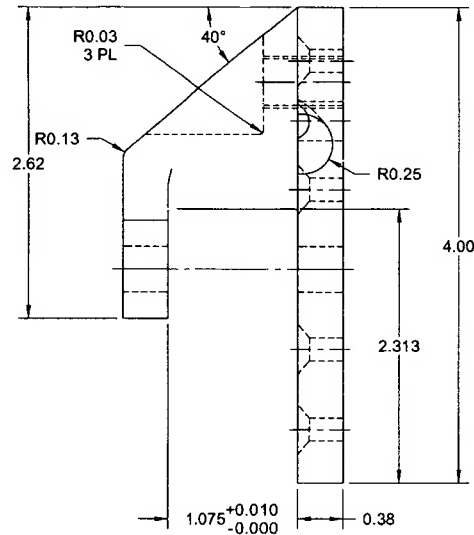
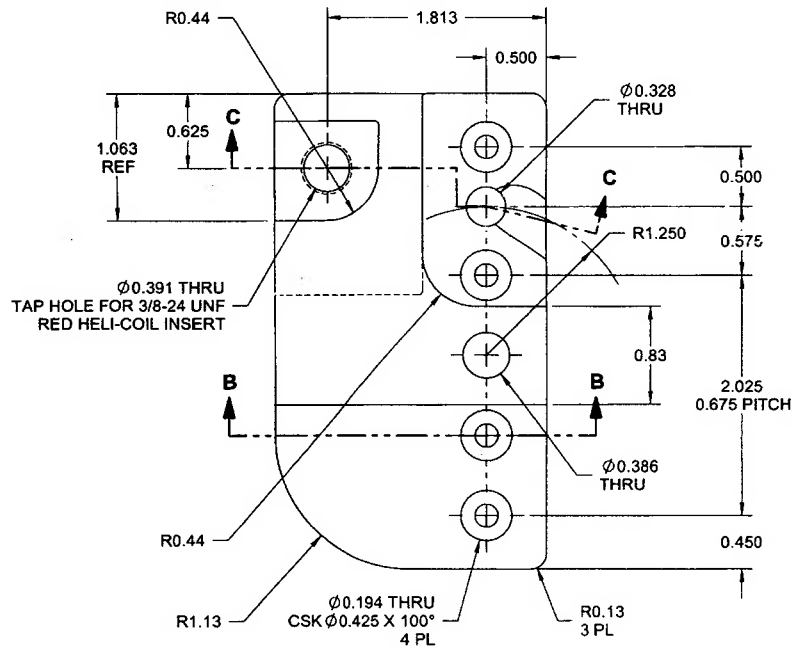
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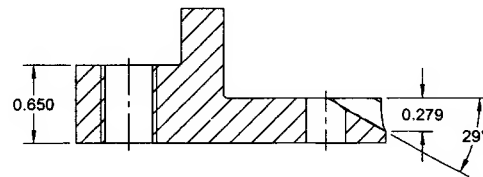
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SECTION B-B



SECTION C-C

D3695-3 STOPPER

RELEASED
2010-11-25

D3695-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART
QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.19 lbs

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	<i>[Signature]</i>	DRAWING NO. D3695	REV. D
MFG. APPR.	<i>[Signature]</i>	TITLE SLIDER ASSEMBLY	SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	SCALE NTS	
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